

Work Order ID 80243

80243

Page 1

February-15-12 3:30:31 PM

Item ID: D3436-044 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step RH
 Start Date: 15/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 29/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.C.S Date: 12/02/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3436	Rev A

100 0.00
100 Large Fab
 Large Fab
 Large Fab

Memo 0.00
 Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436Dwg Rev: A
 Qty Part Number Description Batch
 A/RN/A 4130 Welding Rod M118875
 Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436Dwg Rev: A
 Qty Part Number Description Batch
 A/RN/A 4130 Welding Rod M118875
 Weld cap D3436-7 as per Dwg D3436Dwg Rev: A
 Qty Part Number Description Batch
 A/RN/A 4130 Welding Rod M118875

4 Q 12-11-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80243

February-15-12 3:30:31 PM

80243

Page 2

Item ID: D3436-044

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step RH

Start Date: 15/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1-Slit part D3436-041 on bandsaw as per Dwg D3436
2- deburr

(4)

12-11-14

120

0.00

120

QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

(4)

12-11-14

DAS
09
2-89

130

0.00

130

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

(4)

12-11-14

DAS
09
2-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
140									
Powdercoat									
Powder Coating									
	Memo	0.00							
	START TIME: 8:00								
	OVEN TEMPERATURE: 400 OF								
	FINISH TIME: 8:30								
145	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
145									
HandFinish									
Hand Finishing									
	Memo	0.00							
	Wing Walk B								
150	QC3- Inspect Part Finish	0.00							
150									
QC									
Quality Control									
	Memo	0.00							

M122878

M423652

M123652

4 12 11-15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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80243

Page 4

N900040100

Stop ***NS2***

4

4

Run Start *NR1*

Stop ***NR2***

Date:

**Insp.
Stamp**

155

Bond pads per dwg and QSI 015

M123 557

160

0.00

0.00

170

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

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Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/11/20 JJ

muf
12-11-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

February-15-12 3:30:34 PM

Page 1

Work Order ID: 80243

80243

Parent Item: D3436-044

D3436-044

Parent Item Name: Step RH

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.05.11New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3436-5		Manufactured	No			100	Each	24.0000	4	16			

D3436-5

Bushing

**

EL 12-11-13

83316 x 11

90511 x 5

Location

Loc Qty

Loc Code

ST044

20

46592

20

WA024

4

75229

4

D3436-7

Manufactured

No

100

Each

35.0000

1

4

D3436-7

Cap

**

EL 12-11-13

Location

Loc Qty

Loc Code

WA021

35

56836

35

D3436-9

Manufactured

No

100

Each

4.0000

2

8

D3436-9

Pad

**

8 FF 12-11-16

Location

Loc Qty

Loc Code

GA

87279

4

79670

4

D3436-4

Manufactured

No

100

Each

3.0000

1

4

D3436-4

Right Step

**

EL 12-11-13

Location

Loc Qty

Loc Code

WA022

3

73545

3

80251 x 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 80243

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Parent Item: D3436-044

D3436-044

Parent Item Name: Step RH

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

D3436-1

Manufactured No

155

Each

33.0000

1

4

D3436-1

**

EL 12/1/13

Clamp

Location

Loc Qty

Loc Code

WA024

33

17679

33

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

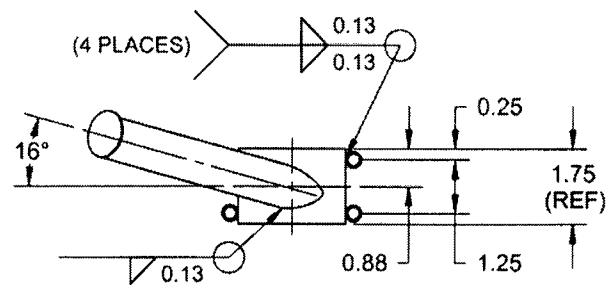
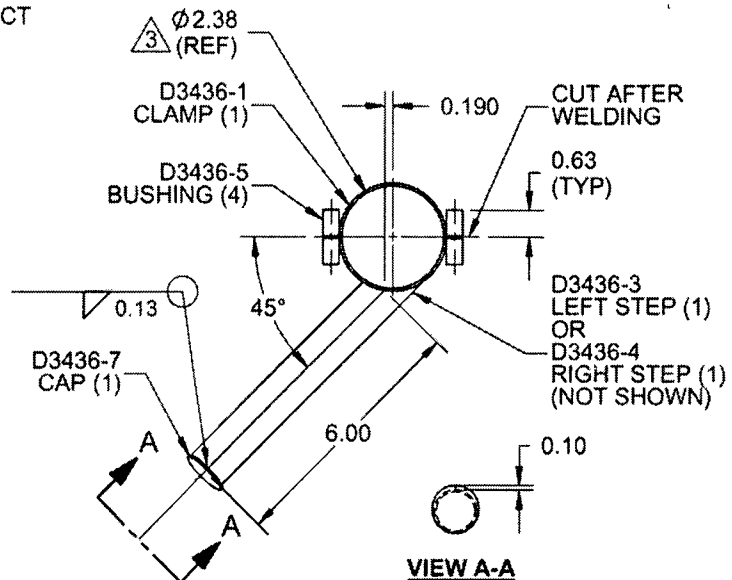
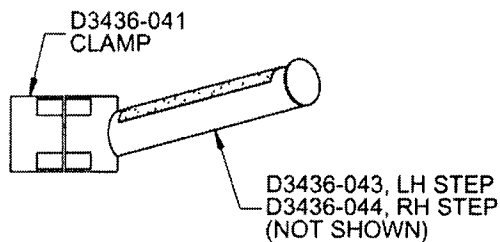
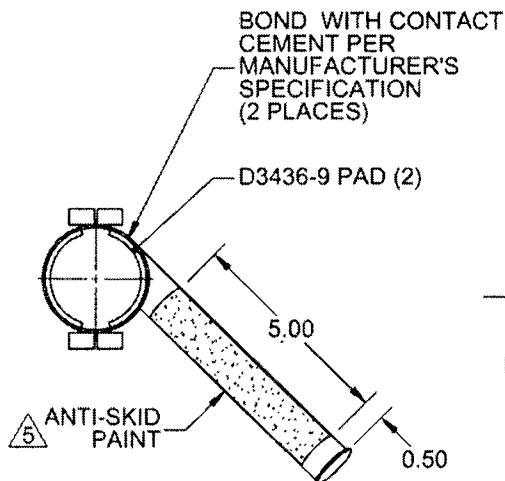
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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:4
A	05.04.28	NEW ISSUE	



WELDING

NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27 [Signature]

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Dart Aerospace Ltd

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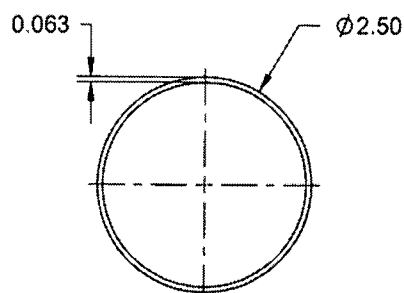
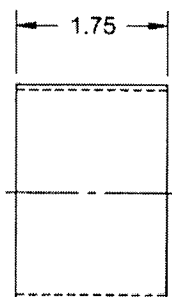
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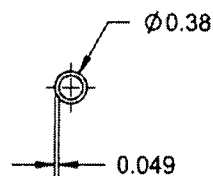
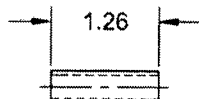


DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

05-05-27

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80243

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

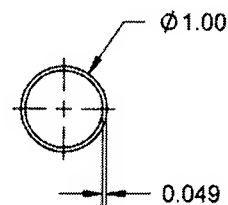
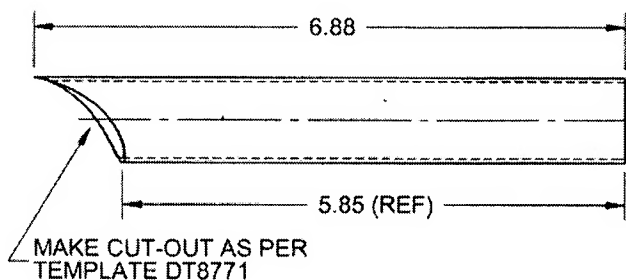
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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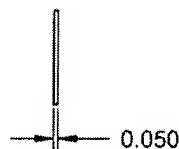
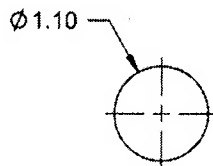
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-05-27 H

D3436-3/-7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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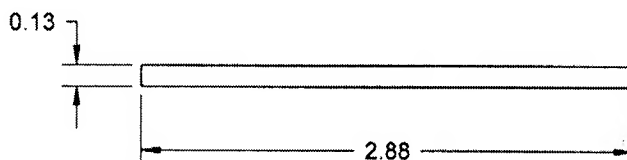
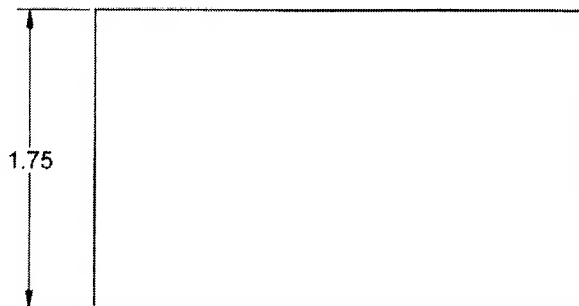
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CHECKED H	APPROVED H	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:1



RELEASED
05-05-27 H

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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